



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D3179-041

Job Sheet 185498



Part No: D3179-041

Job Qty: 4 ea

Part Name: Litter Tie Down (Non-Locking)



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 10/29/18

Job Tracking No:

Due Date: 11/16/18

Created By: Jesse White

Type: Stock

Description:

Note: DWG REV E IPP A1 03.01.09 Added Acid etch end alodine RF IPP Rev:B Added Powder Coat 07-07-04 JLM
IPP REV:C AS PER REV D JLM 13-05-24 VERIFIED BY:DD IPP Rev:C 08-12-10 add part list DD verified
by:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	4 Ea	11/16/18	11/16/18	0.00	0.00	Start Up Machining-1		DAS 18/11/11
100	Bandsaw	4 pcs	11/16/18	11/16/18	0.00	0.33	Bandsaw1		52 18/11/11
110	CNC Vertical Machining	4 pcs	11/16/18	11/16/18	0.37	7.27	HAAS1-3		9-89 18/11/11
120	QC	4 pcs	11/16/18	11/16/18	0.00	0.00	QC2 Machining-1		ADSPB-1-07
130	QC	4 pcs	11/16/18	11/16/18	0.00	0.00	QC8 Machining-1		18/11/13
140	HandFinish	4 pcs	11/16/18	11/16/18	0.00	0.32	HandFinish1		D.R. 18/11/13
150	QC	4 pcs	11/16/18	11/16/18	0.00	0.00	QC7-2		DL 18-11-13
160	Powdercoat	4 pcs	11/16/18	11/16/18	0.00	0.24	Powdercoat1		BL 18-11-13 AS
170	QC	4 pcs	11/16/18	11/16/18	0.00	0.00	QC3		NOV 13 2018 68
180	Small Fab	4 pcs	11/16/18	11/16/18	0.00	0.60	Small Fab-3		Smb DAS
190	QC	4 pcs	11/16/18	11/16/18	0.00	0.00	QC5		NOV 27 2018 68
200	Packaging	4 pcs	11/16/18	11/16/18	0.00	0.00	Packaging3-1		NOV 27 2018 6 9-89
210	QC21-SA	4 Ea	11/16/18	11/16/18	0.00	0.00	QC21		NOV 27 2018 6 9-89

Part Op 100 - Cut blanks: 12.150" long
Descriptions: 110 - 1- Mill as per Folio FA297 Rev: & Dwg D3179-1 Rev:
160 - START TIME: 1:50 O.T. 3000 FINISH: 2.00
180 - Assemble as per Dwg D3179

M 138451

NOV 27 2018
5018334

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D6201	T Extrusion	4.0500 ft (1.0125 ea)	90-Start up Operation	5018334
D2372 GA118	Quick Release	8 Ea (2 ea)	180-Small Fab	5129024 X10
D2444	Pip Pin Assembly	4 Ea (1 ea)	180-Small Fab	5127100
MS21042L3 st300	Nut	4 Ea (1 ea)	180-Small Fab	5004592
MS27039-1-13 st200	Screw	4 Ea (1 ea)	180-Small Fab	5071833
NAS1149D0332J st24	Washer	12 Ea (3 ea)	180-Small Fab	5100407

open hole to .246 #10

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____ Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="width:15%;">Skid-tube</td><td style="width:5%;">☐</td> <td style="width:15%;">Cross tube</td><td style="width:5%;">☐</td> <td style="width:15%;">Water Jet</td><td style="width:5%;">☐</td> <td style="width:15%;">Engineering</td><td style="width:5%;">☐</td> </tr> <tr> <td>Machining</td><td>☐</td> <td>Small Fab</td><td>☐</td> <td>Prod. Eng. Coord.</td><td>☐</td> <td>Quality</td><td>☐</td> </tr> <tr> <td>Thermoforming</td><td>☐</td> <td>Finishing</td><td>☐</td> <td>Rec/Store/Packaging</td><td>☐</td> <td>Other</td><td>☐</td> </tr> <tr> <td>Large Fab</td><td>☐</td> <td>Composite</td><td>☐</td> <td>Supplier</td><td>☐</td> <td></td><td></td> </tr> </table>						Skid-tube	☐	Cross tube	☐	Water Jet	☐	Engineering	☐	Machining	☐	Small Fab	☐	Prod. Eng. Coord.	☐	Quality	☐	Thermoforming	☐	Finishing	☐	Rec/Store/Packaging	☐	Other	☐	Large Fab	☐	Composite	☐	Supplier	☐																																																																													
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Dart Aerospace Ltd. 1270 Aberdeen Street, Hamilton, ON K6A 1K7 CANADA TEL: 905.332.5200 Email: sales@dartaero.com www.dartaerospace.com Date: 11/11/18 DART AEROSPACE Container No: S126650 Part: D3179-041 Job No: 185498 Serial No/ Batch: S126650 Revision: Inspector: Exp Date: Instructions: Various STC's																																																																																																																				
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Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D6201	4	22	0
180-Small Fab	D2372	8	2	0
	D2444	4	1	0
	MS21042L3	4	2,373	0
	MS27039-1-13	4	440	0
	NAS1149D0332J	12	1,940	0
Part Specifications				
Specifications could not be found.				

Plex 10/29/18 12:56 PM dart.white.jesse

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____ Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width: 100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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								Lead hand / Supervisor Approval Verification																	
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Root Cause		FAULT CATEGORY																							
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐	OTHER :																			

DART AEROSPACE LTD		Work Order: 18.5498
Description: Litter Tie Down (Non-Locking)		Part Number: D 3179-041
Inspection Dwg:	Rev:	Page 1 of 1

INSPECTION SHEET

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.00	±.030	0.9995	✓		Vern.	2 PL
R0.40	±.030	0.40	✓		R.G.	6 PL
1.000	±.010	0.998	✓		Vern.	3 PL
0.750	±.010	0.747	✓		"	
1.50	±.030	1.50	✓		"	3 PL
Ø0.246	+1.005/-1.001	0.247	✓		"	2 PL
4.250	±.010	4.250	✓		"	
Ø0.191	+1.005/-1.001	0.193	✓		"	
10.500	±.010	1.500	✓		"	
1.70	±.030	1.699	✓		H.G.	2 PL
R0.38	±.030	0.375	✓		R.G.	10 PL
3.31	±.030	3.311	✓		Vern.	
2.88	±.030	2.875	✓		"	
2.125	±.010	2.125	✓		H.G.	3 PL
1.38	±.030	1.375	✓		Vern.	
1.00	±.030	1.002	✓		H.G.	2 PL
0.50	±.030	0.4995	✓		Vern.	
1.000	±.010	0.999	✓		"	
4.50	±.030	4.510	✓		"	
7.50	±.030	7.50	✓		"	
9.000	±.010	9.002	✓		"	
12.00	±.030	12.000	✓		H.G.	
R0.375	±.010	0.375	✓		R.G.	3 PL
R0.50	±.030	0.500	✓		"	
Ø0.191	+1.005/-1.001	0.193	✓		Vern.	2 PL
R0.25	±.030	0.250	✓		R.G.	4 PL
R0.375	±.010	0.375	✓		"	2 PL
●R0.38	±.030	0.375	✓		"	2 PL
4.00	±.030	4.00	✓		Vern.	

Measured by: DJT	Checked by: gman	QC Inspector:
Date: 18-11-09	Date: 18/11/13	Date:

Engineering Approval: (if necessary)	Date:
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Rev	Date	Change	Revised by	Approved
B	14.07.31	New Issue	KJ	

BSH

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